BULLETIN NO.
54-06-2640

SERVICE PARTS LIST

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18 CORDLESS CAULK and ADHESIVE GUN			Aug. 2016
CAT. NO. 2640-20 (Bare Tool)	SERIAL NUMBER **D15A**	WIRING INSTRUCTION **SEE PAGE 3**	

CAT. NO. 2641-21CT:
Contains 2640-20 and the 10 oz. Quick Change Cartridge Kit shown below.

CAT. NO. 2642-21CT:
Contains 2640-20 and the 20 oz. Aluminum Sausage Cartridge Kit (48-08-1093)

CAT. NO. 2643-21CT:
Contains 2640-20 and the 20 oz. Clear Sausage Cartridge Kit (48-08-1094)

SEE PAGE TWO FOR THE PARTS BREAKDOWN OF THE LARGER 20 OZ. AND QUART CARTRIDGE SYSTEMS

FIG.	PART NO.	DESCRIPTION OF PART	QTY.
1	44-94-0660	10 oz. Rod Assembly (Incl. rod & magnet)	(1)
2	45-88-2640	Wave Washer	(1)
3	31-50-2100	Handle Assembly with Speed Dial	(1)
4	23-66-2645	Switch Assembly with PCBA	(1)
7	45-04-2050	M5 x .75 Flat Hd. T-25 Security Screw	(1)
8	31-44-1030	Rod Handle	(1)
9	---------------	Rod for 10 oz. Cartridge	(1)
10	44-70-0330	10 oz. Plunger	(1)
11	45-04-2015	M5 x .625 Flat Hd. Phillips Screw	(1)
12	31-01-1800	10 oz. Cartridge Holder	(1)
13	44-40-0900	Barrel Nut	(1)
14	45-88-1495	Flat Washer	(1)
15	42-52-0440	Cartridge Cap	(1)
16	31-86-0375	Spacer	(1)
17	45-04-1090	Hex Skt. Bolt	(3)
18	28-50-2070	Front Plate	(1)
19	42-32-0800	Barrel Bolt	(1)

EXAMPLE:
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Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

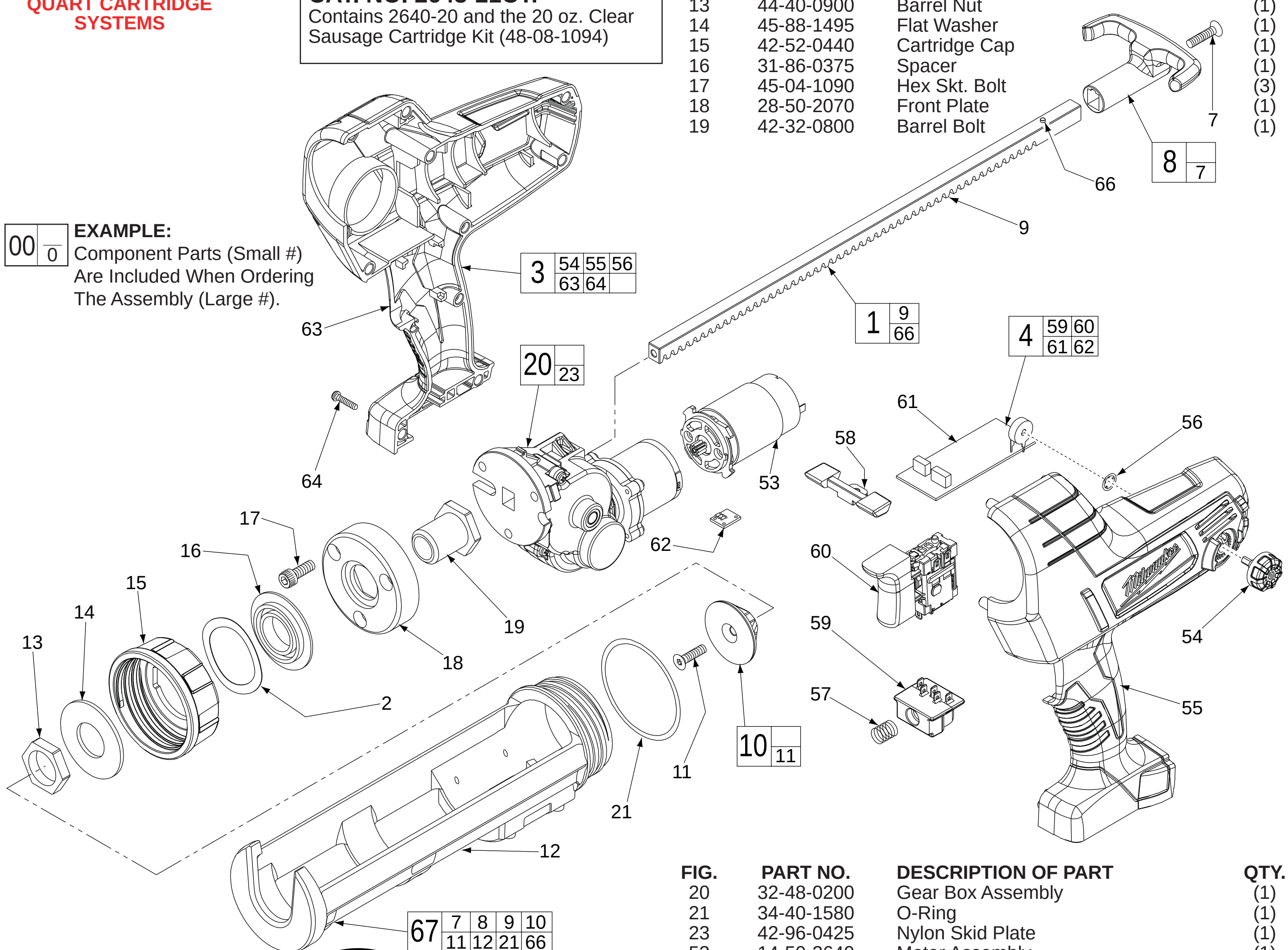
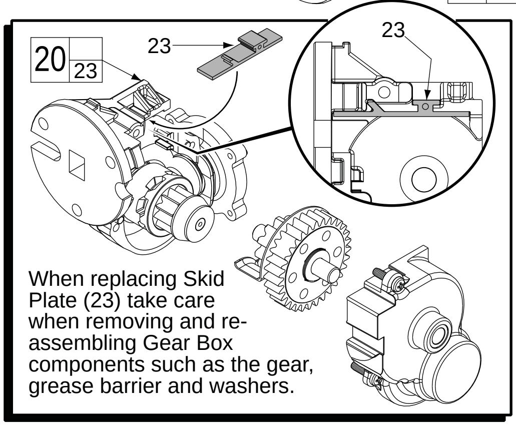


FIG.	PART NO.	DESCRIPTION OF PART	QTY.
20	32-48-0200	Gear Box Assembly	(1)
21	34-40-1580	O-Ring	(1)
23	42-96-0425	Nylon Skid Plate	(1)
53	14-50-2640	Motor Assembly	(1)
54	43-98-0780	Speed Dial	(1)
55	---------------	Left Handle Halve	(1)
56	42-70-1125	Retainer/External Nut	(1)
57	40-50-1090	Terminal Block Spring	(1)
58	45-24-1250	Shuttle Lock	(1)
59	---------------	Terminal Block	(1)
60	---------------	Switch	(1)
61	---------------	PCBA	(1)
62	---------------	Hall Sensor (Electronic Switch)	(1)
63	---------------	Right Handle Halve	(1)
64	06-82-2025	Pan Hd. Plastite T-10 Screw	(12)
66	---------------	Rod Magnet	(1)
67	48-08-1076	10 oz. Quick Change Carriage Kit	(1)
	12-20-2640	Service Nameplate (Not Shown)	(1)



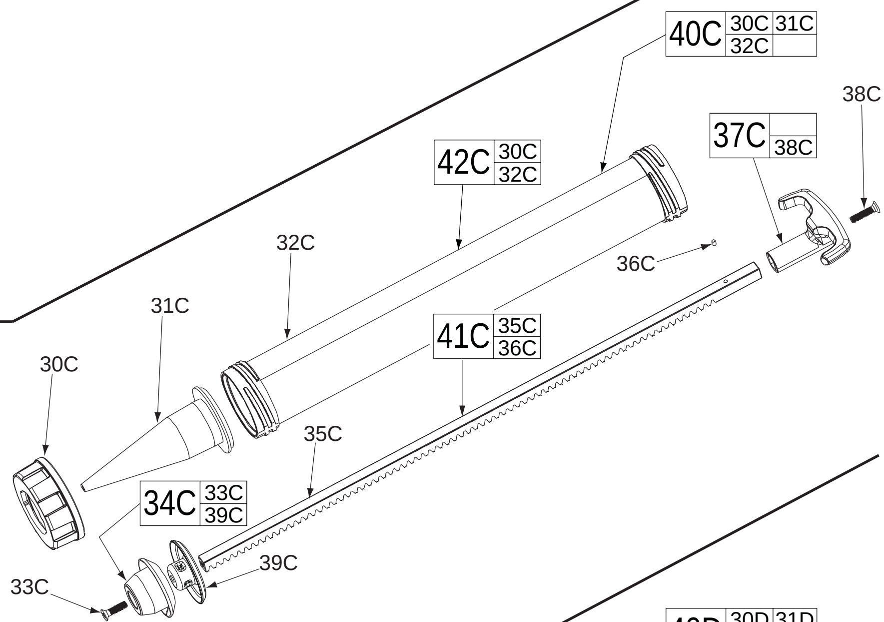
When replacing Skid Plate (23) take care when removing and re-assembling Gear Box components such as the gear, grease barrier and washers.

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005
Drwg. 5

CAT. No. 2642-21CT
Contains the 2640-20 (bare tool) and the cartridge system below.

20 Oz. ALUMINUM SAUSAGE CARTRIDGE KIT
Cat. No. 48-08-1093

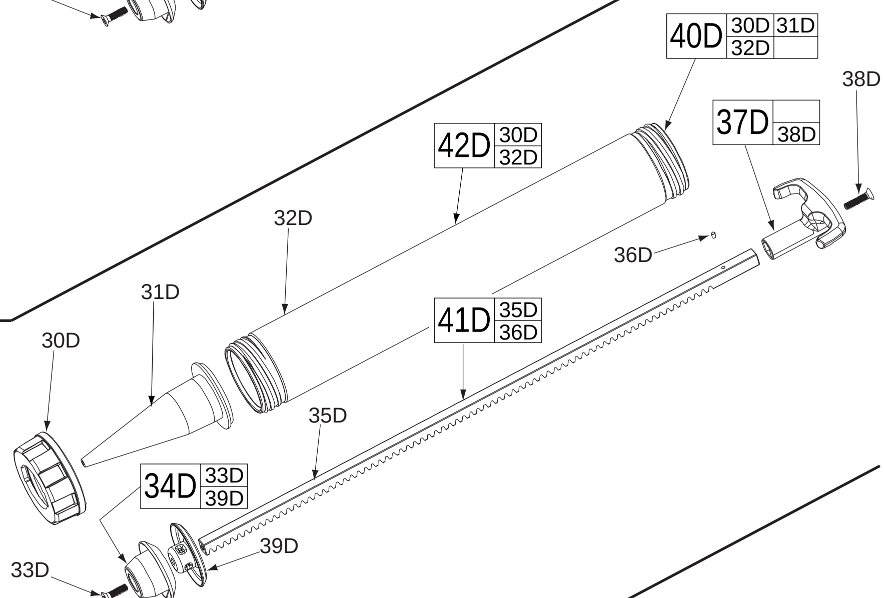
Fig.	Part No.	Description of Part
30C	42-52-0440	Cartridge Cap
31C	31-12-0700	Nozzle - Black
32C	---------------	20 oz. Aluminum Barrel
33C	45-04-2015	Plunger Screw
34C	44-70-0375	Sausage Plunger
35C	---------------	Plunger Rod
36C	---------------	Magnet
37C	31-44-1030	Plunger Handle
38C	45-04-2050	Handle Screw
39C	---------------	Plunger Back Plate
40C	48-08-1091	20 oz. Aluminum Sausage Barrel Kit
41C	44-94-0675	20 oz. Plunger Rod Assembly
42C	45-76-0900	20 oz. Aluminum Barrel Assembly



CAT. No. 2643-21CT
Contains the 2640-20 (bare tool) and the cartridge system below.

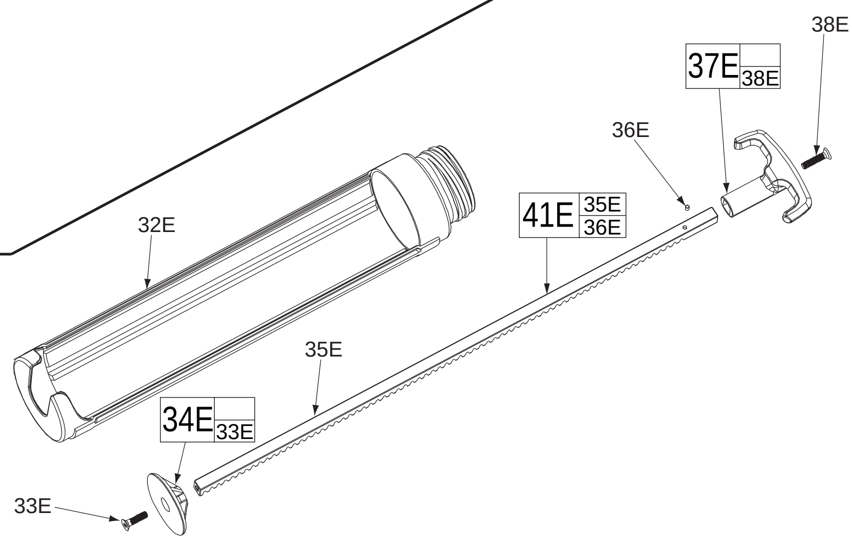
20 Oz. CLEAR (Plastic) SAUSAGE CARTRIDGE KIT
Cat. No. 48-08-1094

Fig.	Part No.	Description of Part
30D	42-52-0440	Cartridge Cap
31D	31-12-0700	Nozzle - Black
32D	---------------	20 oz. Clear (Plastic) Barrel
33D	45-04-2015	Plunger Screw
34D	44-70-0375	Sausage Plunger
35D	---------------	Plunger Rod
36D	---------------	Magnet
37D	31-44-1030	Plunger Handle
38D	45-04-2050	Handle Screw
39D	---------------	Plunger Back Plate
41D	44-94-0675	20 oz. Plunger Rod Assembly
42D	45-76-0925	20 oz. Clear (Plastic) Barrel Assembly
40D	48-08-1096	20 oz. Clear (Plastic) Barrel Kit



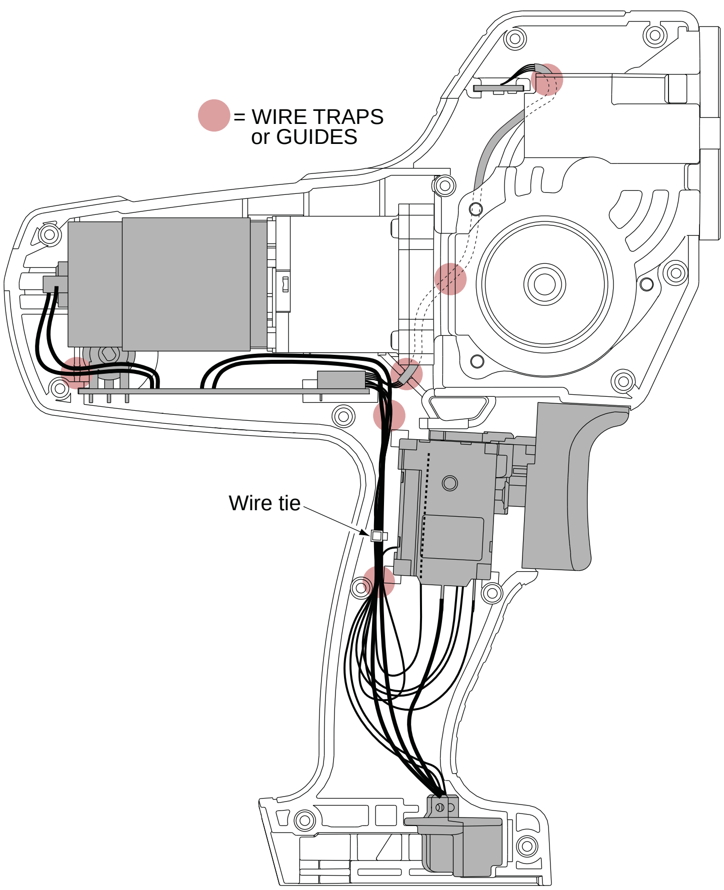
CAT. No. 48-08-1095
QUART CARTRIDGE CARRIAGE and corresponding components

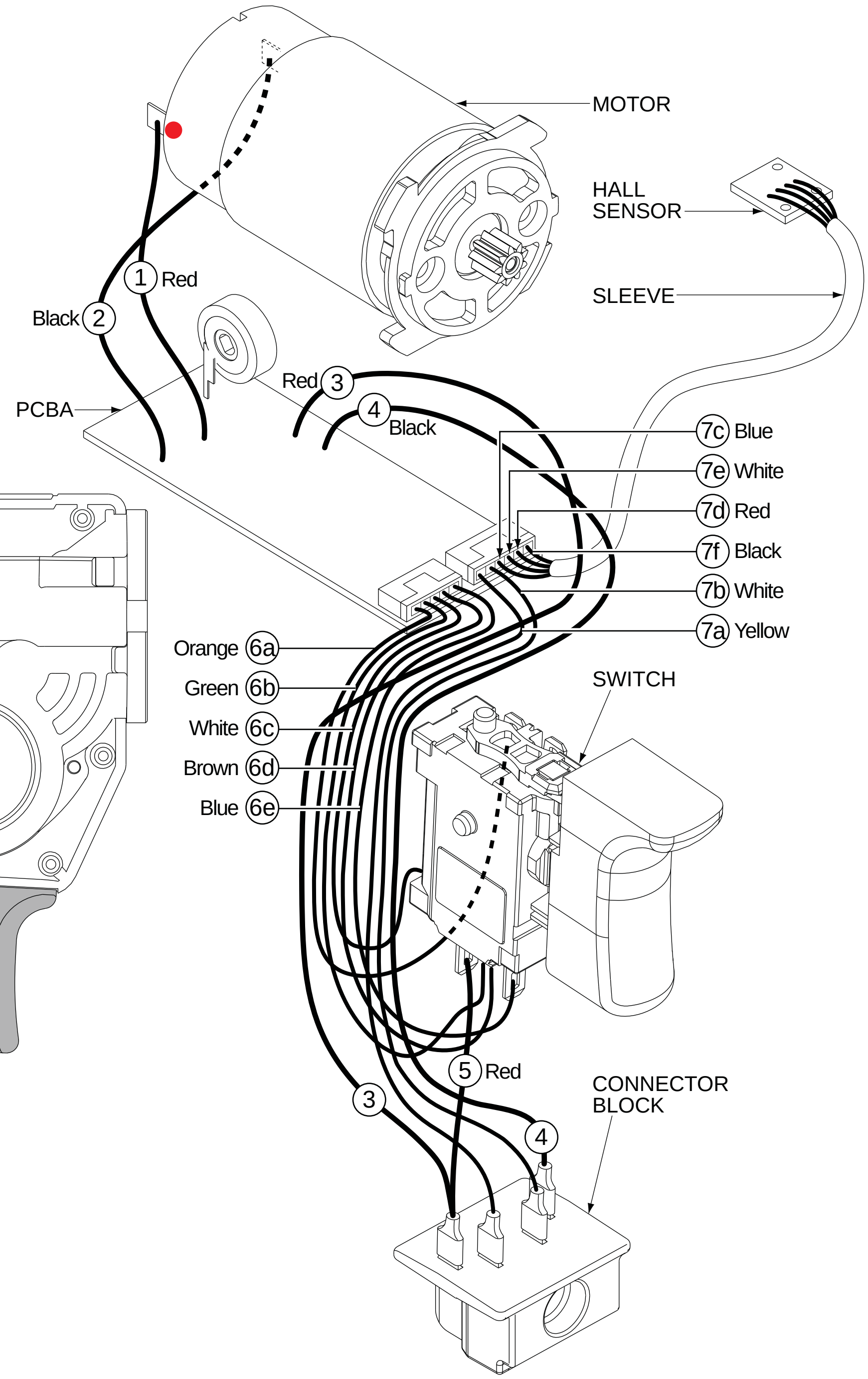
Fig.	Part No.	Description of Part
32E	31-01-1810	Quart Cartridge Carriage
33E	45-04-2015	Plunger Screw
34E	44-70-0340	Quart Plunger
35E	---------------	Plunger Rod
36E	---------------	Magnet
37E	31-44-1030	Plunger Handle
38E	45-04-2050	Handle Screw
41E	44-94-0680	Quart Plunger Rod Assembly



AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.





WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Part No.	Gauge	Length	Terminals, Connectors and End Wire Preparation
1	Red	23-66-2645	-----	-----	Component of PCBA on Switch Assembly. Solder to right terminal on motor (marked with red dot).
2	Black	23-66-2645	-----	-----	Component of PCBA on Switch Assembly. Solder to left terminal on motor.
3	Red	23-66-2645	-----	-----	Component of PCBA on Switch Assembly. Attached to PCBA and wire #5 on connector block.
4	Black	23-66-2645	-----	-----	Component of PCBA on Switch Assembly. Attached to PCBA and connector block.
5	Red	23-66-2645	-----	-----	Component of Switch Assembly. Attached to switch and wire #3 at the connector block.
6a	Orange	23-66-2645	-----	-----	Component of Switch Assy. Part of a 5 wire terminal block connecting to the PCBA and switch.
6b	Green	23-66-2645	-----	-----	Component of Switch Assy. Part of a 5 wire terminal block connecting to the PCBA and switch.
6c	White	23-66-2645	-----	-----	Component of Switch Assy. Part of a 5 wire terminal block connecting to the PCBA and switch.
6d	Brown	23-66-2645	-----	-----	Component of Switch Assy. Part of a 5 wire terminal block connecting to the PCBA and switch.
6e	Blue	23-66-2645	-----	-----	Component of Switch Assy. Part of a 5 wire terminal block connecting to the PCBA and switch.
7a	Yellow	23-66-2645	-----	-----	Comp. of Switch Assy. Part of a 6 wire terminal block connecting to the PCBA and connector block.
7b	White	23-66-2645	-----	-----	Comp. of Switch Assy. Part of a 6 wire terminal block connecting to the PCBA and connector block.
7c	Blue	23-66-2645	-----	-----	Comp. of Switch Assy. Part of a 6 wire terminal block connecting to the PCBA and hall sensor.
7d	Red	23-66-2645	-----	-----	Comp. of Switch Assy. Part of a 6 wire terminal block connecting to the PCBA and hall sensor.
7e	White	23-66-2645	-----	-----	Comp. of Switch Assy. Part of a 6 wire terminal block connecting to the PCBA and hall sensor.
7f	Black	23-66-2645	-----	-----	Comp. of Switch Assy. Part of a 6 wire terminal block connecting to the PCBA and hall sensor.